

Work Order ID 128080

128080

Page 1

Tuesday, January 06, 2015 9:25:12 AM

Item ID: D350-636-012

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Stop *NS2*

Start Date: 1/6/2015 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 1/6/2015 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: MLS Date: 15-01-06 Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2750-042	G								
D3492	C								

100 Document Control 0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

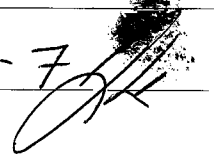
Doc.Control -USB or Paperwork

record fwd angle: 89.6°

Photocopy blue file and type labels per PPP D350-636-012 CHG 007

DAS
46
9-89

JAN 31
JAN 31 2015

15-1-7 

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Item ID: D350-636-012**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible**Start Date:** 1/6/2015 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 1/6/2015 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

110

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D2750

3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.

ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE

Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill Jig DT8150 & DT8863A for second side only DT8863B for first side (detail K)

4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade fitting. Open to 0.500" using hole saw. VERIFY AND RECORD FWD BEND ANGLE.

5- Drill only two fwd step holes using DT9616. Ensure proper positioning.

6- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to 0.297".

7- Open up holes of Detail J to 0.297" (total of 2 holes per side)

8- Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left from bending as per QSI 004

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15-0107

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Setup Start *NS1*

Stop *NS2*

Stop *NS2*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Description	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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9- Grind welds flush as per Dwg D2750

120

Quality Control

Memo	0.00
-------------	------

Memo	0.00
-------------	------

130

Quality Control

1 DAS 38 9-89
9-89
JAN 07 2015

1

DAS
68
9-89

DAS
38
9-89

JAN 07 2015

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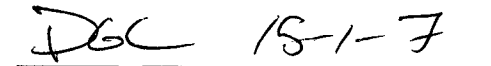
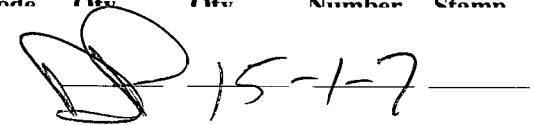
Tuesday, January 06, 2015 9:25:12 AM

Item ID: D350-636-012**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible**Start Date:** 1/6/2015 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 1/6/2015 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:**

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____
QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Run Start *NR1***Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
150									
QC	Memo	0.00							
Quality Control									



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Item ID: D350-636-012

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/6/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID 160	Operation Description	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 Skidtubes	Skidtubes	Memo 0.00							
Skidtubes	1- Open up holes of Detail L using hole saw and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2- Open up holes of Detail K using hole saw to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3- Open float holes using uni-bit to .500" (4 per Side)								
	4- Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)								
	5- Deburr and blow out all chips from inside of tube								
	6- Prepare tube for welding, remove alodine as required.								
	7- Bond web D2739 in place as per QSI 015, let cure for 12hrs. A/R Sikaflex-291 batch: <u>131120</u> exp. date: <u>15-10-21</u>								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: <u>M130812</u>								
	9- At section AP-AP drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								
	11- Spot face ground handling holes section (total of 4 places per side) as per								

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Item ID: D350-636-012**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Item Name:** Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible**Stop *NS2*****Start Date:** 1/6/2015 **Start Qty:** 1.00 ***1*****Cust Item ID:****Required Date:** 1/6/2015 **Req'd Qty:** 1.00 ***1*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
	dwg D2750								
	12- Deburr holes, ensure tube is free of all scratches before sending to paint.								
170	QC10- Inspect visual per QSI004- ground welds	0.00							
170									
QC	Memo	0.00							DAS 9 9-89
Quality Control									
180	QC5- Inspect part completeness to step on W/O	0.00							
180									
QC	Memo	0.00							DAS 9 9-89
Quality Control	***VERIFY C'BOARD IS GOOD***								

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	Pressure Wash per QSI005 4.3	0.00							DAS 41 9-89
190						1			15-1-15
HandFinish	Memo	0.00							
Hand Finishing	Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.								
200		0.00							DAS 41 9-89
200						1			15-1-15
SprayPaint	Memo	0.00							
Spray Painting	1- PRIME AS PER DWG AND QSI 005 4.2 PRIMER PRC DESOTO 515X349 BATCH: <u>128975</u>								
	2- PAINT WHITE AS PER DWG AND QSI 005 4.2 PAINT BATCH: <u>130858</u>								
210	QC14- Inspect Spray Paint	0.00							
210						1 R H	cf	15/6/22	
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								

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Item ID: D350-636-012

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N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/6/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	HandFinishing	0.00							
230	HandFinish	0.00							
Hand Finishing	Memo 1-Install inserts as per dwg D2750 2-Inspect for Foreign Objects 3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750 SIKA FLEX 241 BATCH: <u>M131120</u> EXP DATE: <u>15/09</u> 4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube A/R 55-o'ring lube batch: <u>M125304 RTU 598 1341K M125792 exp 15/06</u> 5-Coat all exposed fasteners with "LPS Procyon" batch: <u>AA 122900</u>								
240	QC5- Inspect part completeness to step on W/O	0.00							
240	QC	0.00							
Quality Control	Memo								

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38
9-89

15-01-27

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Item ID: D350-636-012 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float
 Start Date: 1/6/2015 Start Qty: 1.00 *1* Cust Item ID:
 Required Date: 1/6/2015 Req'd Qty: 1.00 *1* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250							DAS 06 9-89	JAN 29 2015	DAS 28 9-89
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260							DAS 46 9-89	JAN 30 2015	
QC	Memo	0.00							
Quality Control									
270	Packaging	0.00							
270							DAS 46 9-89	JAN 30 2015	
Packaging	Memo	0.00							
Packaging	Package as per PPP D350-636-012								

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Item ID: D350-636-012

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Stop ***NS2***Start Date: 1/6/2015 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 1/6/2015 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center ID
280Operation
Description
QC21- Final Inspection - Work Order ReleaseSet Up/
Run Hours
0.00Tool ID Tool # Plan Accept Reject Reject Insp.
Code Qty Qty Number Stamp***280***
QC

Memo

0.00

Quality Control

MJS 150202

AB.2-2

Picklist Print

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Work Order ID: 128080

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:102.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC IPP REV:K
 AS PER REV F JLM 13-08-22 VERIFIED BY:DD
 IPP Rev:K 06-07-13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC IPP REV:Q 13.08.27 PER ECN13-
 594 DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-BENT-RH		Manufactured	No			110	Each	12.0000	1				
D2600-3-BENT-RH									**				
Extrusion Bent RH													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG002				12					
				125888				12					
D2744		Manufactured	No			110	Each	38.0000	1				
D2744									**				
Cap													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG001				38					
				125894				38					
D2739		Manufactured	No			160	Each	13.0000	1				
D2739									**				
350 I Beam													
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				LG003				13					
				125889				13					

15-1-7

1

0515-01-07

1

DOC 15-1-7

1

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D2743 Manufactured No

160 Each

Start Qty: 1.00
155.0000 8 8

Required Qty: 1.00

D2743

Crossbolt Spacer

BE15-01-08

Location

Loc Qty

Loc Code

LG001

155

125893

8

127636

147

D3490-3

Manufactured No

160 Each

107.0000 4

D3490-3

Cross Bolt Spacer

BE15-01-08

Location

Loc Qty

Loc Code

LG001

107

125903

107

D3490-1

Manufactured No

160 Each

117.0000 4

D3490-1

Cross Bolt Spacer

BE15-01-08

Location

Loc Qty

Loc Code

LG001

117

125902

117

D3631-1

Manufactured No

230 Each

186.0000 8

D3631-1

Washer

15/01/2015

Location

Loc Qty

Loc Code

FP001

186

125912

186

x 8

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D3791-1

Manufactured No

230 Each

38.0000 1 1

Required Qty: 1.00

D3791-1

Wearpad

**

15/01/22

Location

Loc Qty

Loc Code

FP002

38

125913

38

X1

D3793-3

Manufactured No

230 Each

40.0000 1 1

D3793-3

Wearplate Aft

**

15/01/22

Location

Loc Qty

Loc Code

FP002

40

125915

40

X1

MS21043-6

Purchased No

230 Each

214.0000 4 4

MS21043-6

NUT

**

15/01/22

Location

Loc Qty

Loc Code

FG

20

103693

20

FP001

194

m130325

6

m130726

188

X4

D3794-1

Manufactured No

230 Each

36.0000 1 1

D3794-1

Gasket Fwd

**

15/01/22

Location

Loc Qty

Loc Code

FP001

36

124438

1

125916

35

X1

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Work Order ID: 128080

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

NAS1611-010

Purchased No

230 Each

Start Qty: 1.00
188.0000 8 8

Required Qty: 1.00

NAS1611-010

O-RING

**

ll 1/10/12

Location

Loc Qty

Loc Code

FP001

188

m130797

188

D2741

Manufactured No

250 Each

11.0000

**

1 1 1

✓

125892 1

DAS
06
9-89

D2741
Replacement Blade

DAS
46
9-89

Location

Loc Qty

Loc Code

FG

10

100664

3

113640

2

115522

5

ST538

1

124047

1

JAN 29 2015

DAS
28
9-89

NAS1515H3L

Purchased No

230 Each

695.0000 4 4

**

ll 1/10/12

***NAS1515H3L ***

Washer

Location

Loc Qty

Loc Code

FG

40

102472

40

FP001

99

m127831

99

ST266

556

m127831

56

m130726

500

✓

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

NAS1611-013

Purchased

No

230

Each

Start Qty: 1.00
958.0000 8 8

Required Qty: 1.00

NAS1611-013

O-RING

**

15/01/22

Location

Loc Qty

Loc Code

FP001

958

m130758

958

AN3C6A

Purchased

No

230

Each

616.0000 4 4

AN3C6A

Bolt

**

15/01/22

Location

Loc Qty

Loc Code

CA

39

m128704

39

FG

10

122416

10

FP001

126

m128769

126

ST338a

441

m128769

441

NAS1149C0832R

Purchased

No

230

Each

191.0000 1 1

NAS1149C0832R

Washer

**

15/01/22

Location

Loc Qty

Loc Code

FP001

47

m114915

47

ST271

144

m125807

144

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D3536-25

Manufactured No

230

Each

38.0000

Start Qty: 1.00

1

1

Required Qty: 1.00

D3536-25

Gasket Center

15/01/22

Location

Loc Qty

Loc Code

FG

6

87053

2

95328

4

FP001

32

125909

32

✓1

D3794-3

Manufactured No

230

Each

75.0000

1

1

D3794-3

Gasket Aft

15/01/22

Location

Loc Qty

Loc Code

FP001

75

124948

1

125917

34

127383

39

92658

1

✓1

AN3C5A

Purchased No

230

Each

1,165.000

34

34

AN3C5A

Bolt

15/01/22

Location

Loc Qty

Loc Code

FG

5

122800

5

FP001

17

M130851

17

ST338a

1143

M130770

1000

M130851

143

✓34

Picklist Print

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Work Order ID: 128080

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Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D3537-1 Manufactured No 230 Each 67.0000 Start Qty: 1.00 Required Qty: 1.00
3 3

D3537-1

Wearpad

**

all 15/01/22

Location

Loc Qty

Loc Code

FG	18	13126307	<u>x3</u>
79833	8		
88562	10		
FP001	49		
125418	3		
126306	46		

D3535-25

Manufactured No

230 Each 10.0000 1 1

D3535-25

Wearplate Center

**

all 15/01/22

Location

Loc Qty

Loc Code

FG	2	13127851	<u>41</u>
95077	2		
FP002	8		
125908	8		

D3492-3

Manufactured No

230 Each 210.0000 8 8

D3492-3

Plug

**

all 15/01/22

Location

Loc Qty

Loc Code

FP001	210		<u>x8</u>
125905	210		

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Parent Item: D350-636-012

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Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

NAS1149C0332R Purchased No 230 Each 4,519.000 38 38

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

WASHER

**

all 1/10/12

Location Loc Qty Loc Code

FP001 2657

m130325 2657

GA 126

125654 126

ST271 1736

m130325 736

m130466 1000

x38

D3488-042 Manufactured No

230 Each 2.0000 1 1

D3488-042

Blade Fitting RH

**

all 1/10/12

Location Loc Qty Loc Code

FP001 2 B125900

125901 2

y1

ALS4-1032-225 AELS8-1032-225 Purchased No

230 Each 1,622.000 38 38

ALS4-1032-225

Rivnut

**

all 1/10/12

Location Loc Qty Loc Code

FG 120

M127028 120

FP001 698

M131067 698

st549 804

M131067 804

x38

Tuesday, January 06, 2015 9:25:16 AM

Shop Packet Print

Page 8

Picklist Print

Tuesday, January 06, 2015 9:25:16 AM

Page 9

Work Order ID: 128080

128080

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D3492-1 Manufactured No 230 Each 189.0000 8 8 Start Qty: 1.00 Required Qty: 1.00

D3492-1

Plug

**

all stock

Location Loc Qty Loc Code

FP001 189

125904 189

X8

D3793-1 Manufactured No 230 Each 44.0000 1 1

D3793-1

Wearplate Fwd

**

all stock

Location Loc Qty Loc Code

FP002 44

125914 43

126905 1

X1

AN8C35A Purchased No 230 Each 27.0000 1 1

AN8C35A

Bolt

**

all stock

Location Loc Qty Loc Code

FG 5

121275 5

FP001 22

m130114 1

m130784 21

X1

MS21083C8 Purchased No 230 Each 116.0000 1 1

MS21083C8

Nut

**

all stock

Location Loc Qty Loc Code

ST300 116

m131049 116

X1

Picklist Print

Page 10

Tuesday, January 06, 2015 9:25:16 AM

Work Order ID: 128080

128080

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

D2745

Manufactured No

230

Each

92.0000

Start Qty: 1.00

8 8

Required Qty: 1.00

D2745

Bushing

**

15/01/2015

Location

Loc Qty

Loc Code

FP001

92

11127885

x 8

125895

92

AN6C44A

Purchased

No

230

Each

110.0000

4

4

**

15/01/2015

Location

Loc Qty

Loc Code

FG

2

11327256

x 4

103964

2

FP001

4

1131367

m130863

4

ST286A

17

m130863

17

ST332

11

m130863

11

ST333

76

m131151

76

D3532-1

Manufactured

No

250

Each

32.0000

2

2

**

JAN 29 2015

D3532-1

Spacer

DAS
46
9-89

Location

Loc Qty

Loc Code

ST048

32

125907

32

DAS
86
9-89

DAS
28
9-89

Tuesday, January 06, 2015 9:25:16 AM

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Page 10

Picklist Print

Tuesday, January 06, 2015 9:25:16 AM

Page 11

Work Order ID: 128080

128080

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

MS21083C8	Purchased	No	250	Each	116.0000	Start Qty: 1.00 2 7 2	Required Qty: 1.00	DAS 06 9-89	DAS 28 9-89
MS21083C8						**			
Nut									

Location	Loc Qty	Loc Code
----------	---------	----------

ST300	116	
m131049	116	
		2
		2

NAS1149D0863J	Purchased	No	250	Each	758.0000	2 7 2	DAS 06 9-89	DAS 28 9-89
NAS1149D0863J						**		
Washer								

Location	Loc Qty	Loc Code
----------	---------	----------

FP001	57	
125484	57	
ST260a	700	
125268	600	2
125635	100	
st268	1	
125268	1	

D3493-1	Manufactured	No	250	Each	109.0000	2	DAS 06 9-89	JAN 29 2015
D3493-1						**		
Washer								

Location	Loc Qty	Loc Code
----------	---------	----------

FG	10	
97201	10	
ST046	99	
125906	99	2

ONLY INSTALL IF INSTALLING ON APICAL FLOAT SYSTEM

Picklist Print

Page 12

Tuesday, January 06, 2015 9:25:16 AM

Work Order ID: 128080

128080

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH with Standard Wearplates, DART (Apical) Cylindrical/Aerazur Float Compatible

Start Date: 1/6/2015

Required Date: 1/6/2015

AN8C21A

Purchased

No

250

Each

20.0000

Start Qty: 1.00

Required Qty: 1.00

2 / 2

AN8C21A

DAS

46

9-89

Bolt

**

DAS

65

9-89

Location

Loc Qty

Loc Code

FG

2

123966

2

ST332

18

m131100

18

JAN 29 2015

DAS

28

9-89

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY, LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY, RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY, LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT, LH
	1			D2750-2	SKIDTUBE WELDMENT, RH
		1		D2750-3	SKIDTUBE WELDMENT, LH
			1	D2750-4	SKIDTUBE WELDMENT, RH
1		1		D3488-041	BLADE FITTING, LH
	1			D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225, AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

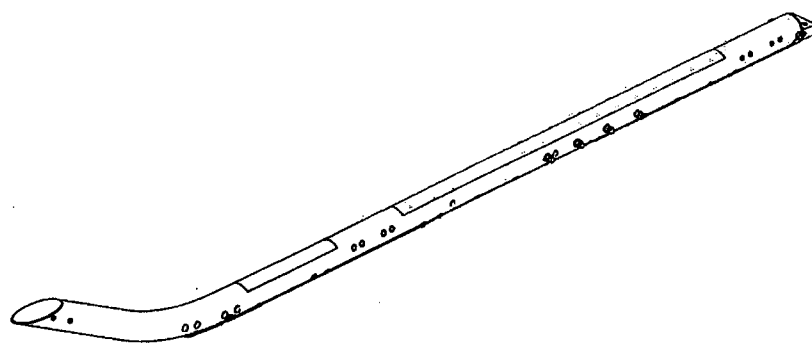
- MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- FINISH: ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2
OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- UNITS: INCHES UNLESS OTHERWISE NOTED
- BREAK SHARP EDGES: N/A
- IDENTIFICATION: N/A
- WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- WELD PER DART QSI 004
- INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF
- FINISH WITH MEK DEGREASER.
- SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

G	CORRECTED TOLERANCE ON $\phi 0.500$ THRU HOLE: IS $+0.010/-0.000$, WAS $+0.100/-0.000$ (ZN B3-4, B2-5); ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-4/-5/-6/-7); UPDATED FINISH OPTIONS; INSIDE OF TUBE NO LONGER SPRAYED WITH LPS-3. REASON: PAR13-276 AND NCR13-2757	MB	13.07.11
F	INCORPORATE DSI 3413; QTY (3) D3537-1 WAS QTY (5) (ZN C8-1); D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1); D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1); ADD D3791-1 (ZN C8-1); WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL); WEARSHOE HARDWARE QTY UPDATED (ZN B8-1); D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11); ADD NOTE 12 AND 13 (ZN A6-1); REASON: REF. NCR 08-043	PH	08.07.16
E	CHANGE TO STAINLESS STEEL WEARPLATES; ADD RUBBER GASKETS; CHANGE INSERTS; ADD D3631-1; REMOVE QTY (38) NAS1515H3L; REMOVE QTY (10) NAS1515H8L; REMOVE D2741; QTY (2) AN960C816; REMOVE QTY (2) MS21083C8	CB	07.05.17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS; INCORPORATE OED 9133/9157	PH	06.01.05
C	ADD D2750-3/D2750-4; INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV.	DESCRIPTION	BY	DATE
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
CHECKED		DRAWING NO. D2750	
MFG. APPR.		SHEET 1 OF 11	
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY	
DE APPR.		SCALE NTS	
DATE	13.07.11	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

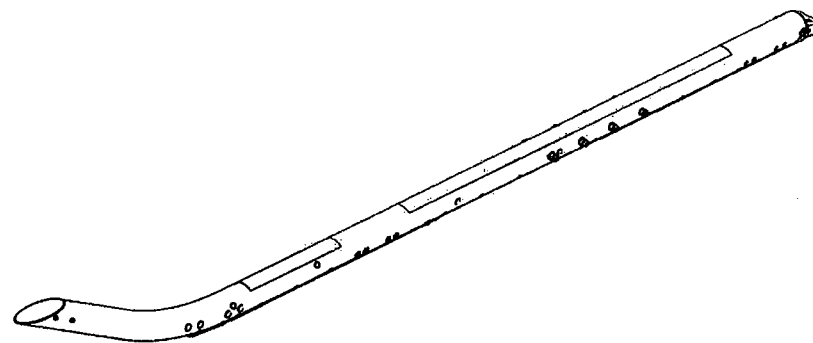
128080_MLJ

1501-06

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2013-08-13
WD



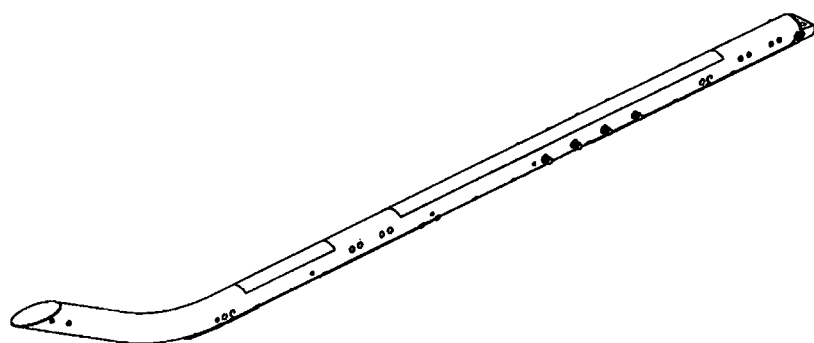
D2750-041 350 SKIDTUBE ASSEMBLY, LH



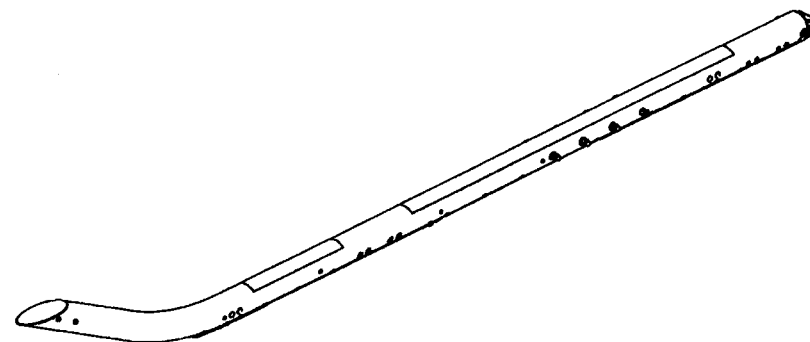
D2750-042 350 SKIDTUBE ASSEMBLY, RH

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MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 2 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
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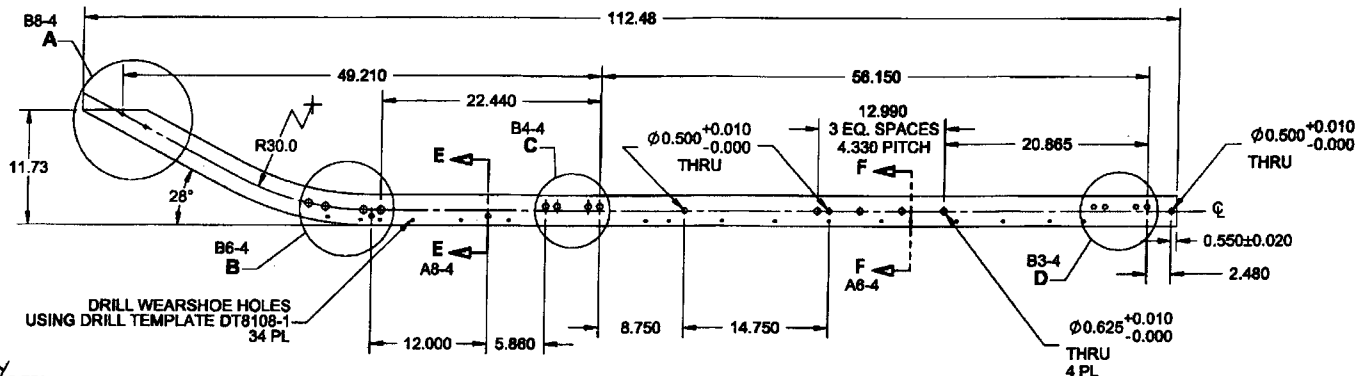
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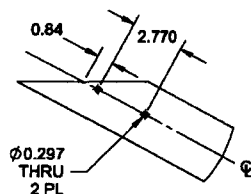
D2750-044 350 SKIDTUBE ASSEMBLY, RH

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2013-08-13
wp

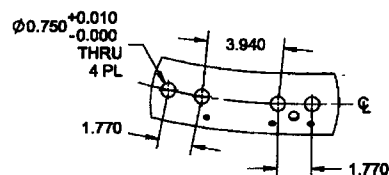
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MFG. APPR.	<i>[Signature]</i>	D2750	SHEET 3 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
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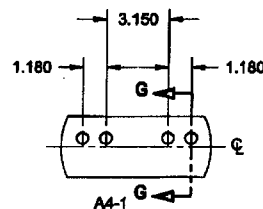
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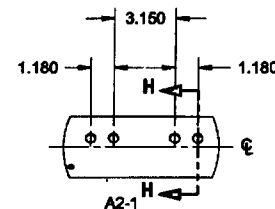
DETAIL A
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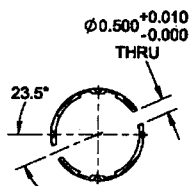
DETAIL B
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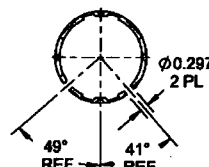
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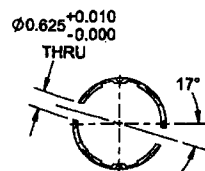
DETAIL D
SCALE 2X



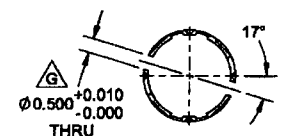
SECTION E-E
SCALE 3X, 2 PL



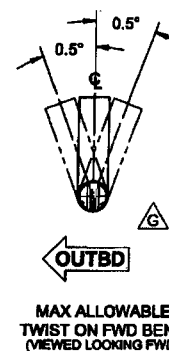
SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



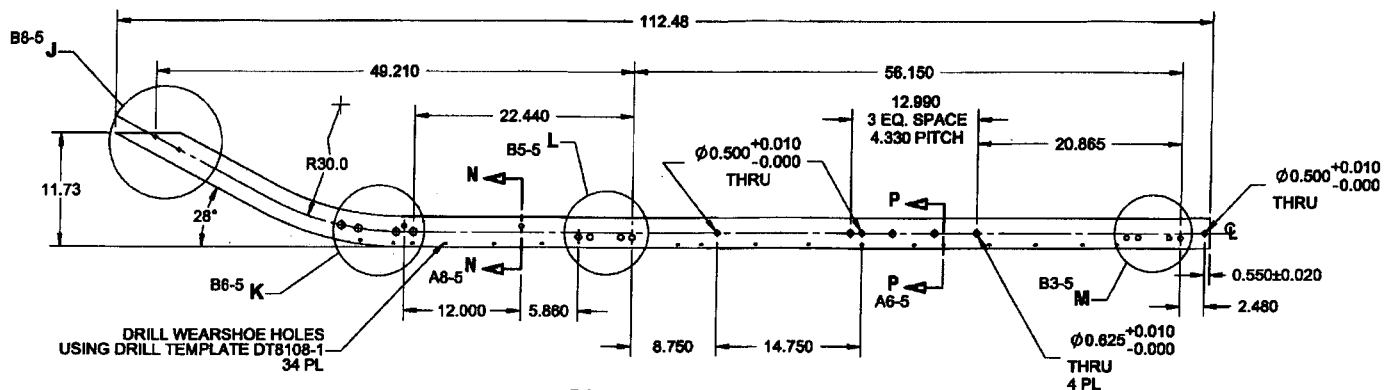
SECTION H-H
SCALE 3X, 4 PL



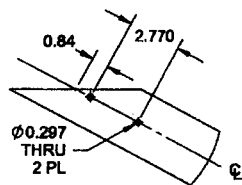
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MFG. APPR.		D2750	SHEET 4 OF 11
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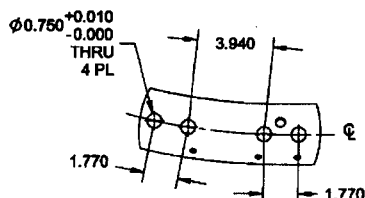
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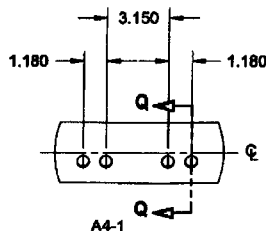
D2750-2 RH SKIDTUBE



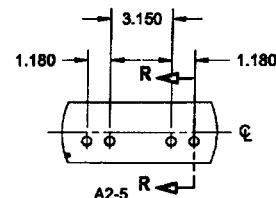
DETAIL J
SCALE 2X



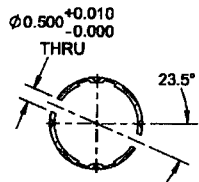
DETAIL K
SCALE 2X



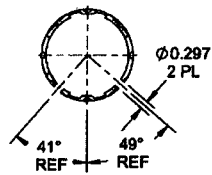
DETAIL L
SCALE 2X



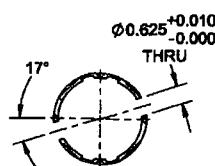
DETAIL M
SCALE 2X



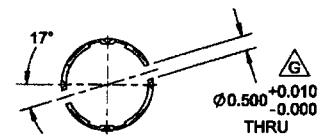
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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MFG. APPR.		D2750	SHEET 5 OF 11
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DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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8 7 6 5 4 3 2 1

8

7

6

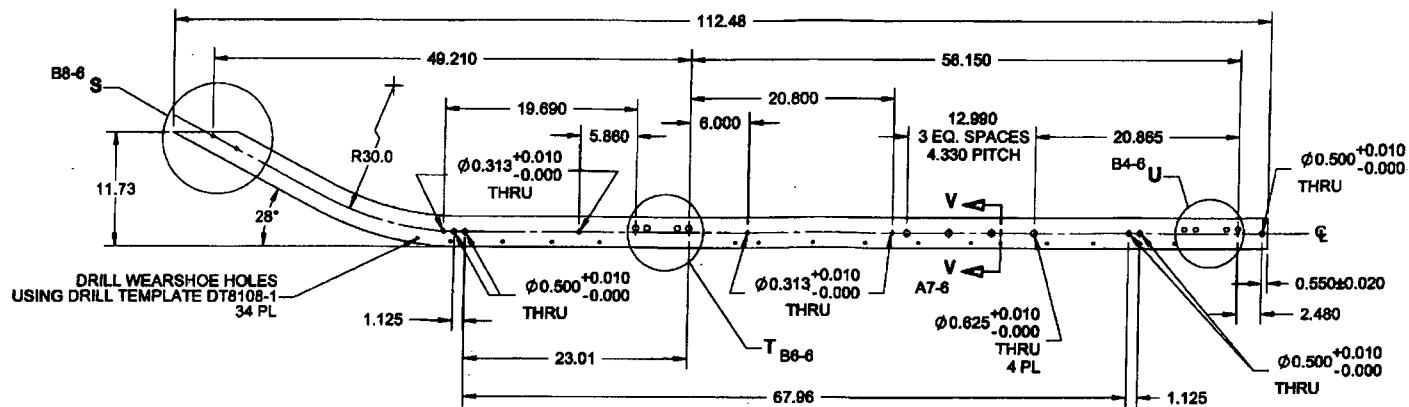
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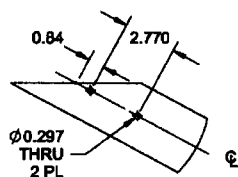
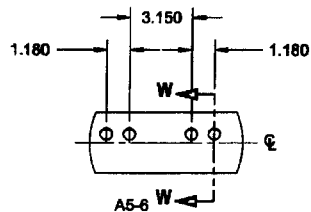
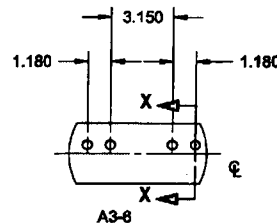
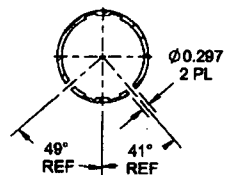
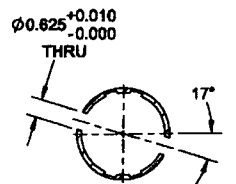
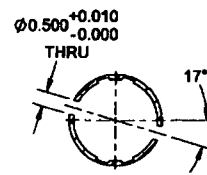
3

2

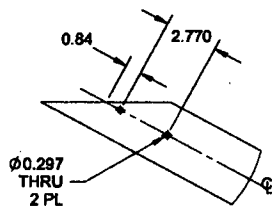
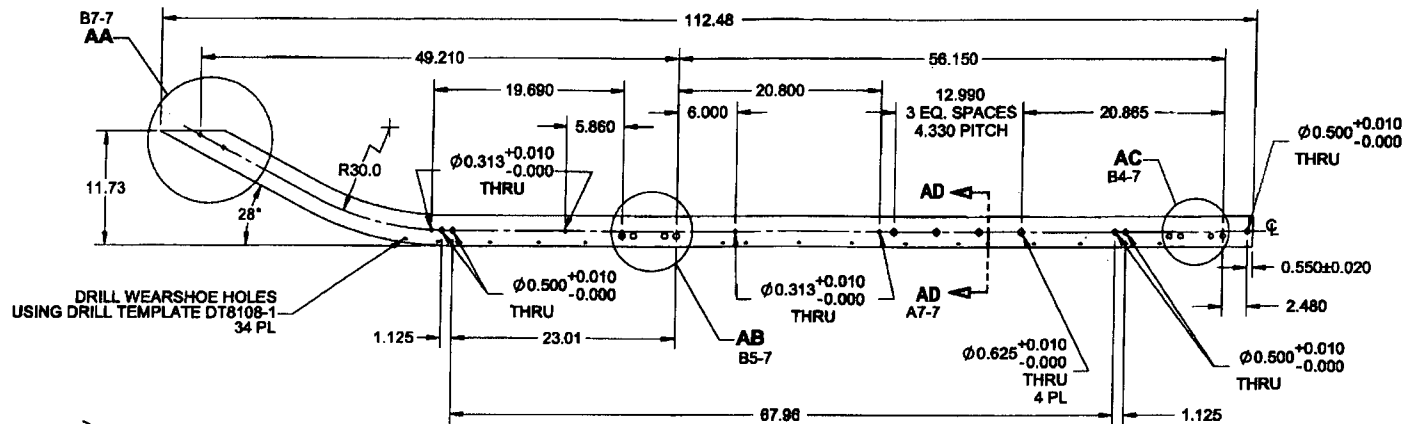
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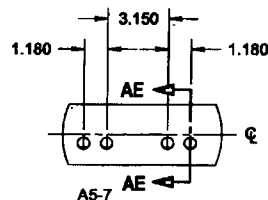
D2750-3 LH SKIDTUBE

DETAIL S
SCALE 2XDETAIL T
SCALE 2XDETAIL U
SCALE 2XSECTION V-V
SCALE 3X, 17° PLSECTION W-W
SCALE 3X, 4 PLSECTION X-X
SCALE 3X, 4 PLRELEASED
2013-08-13

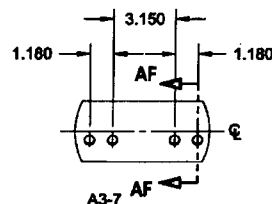
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DRAWN		KENT, WA	
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MFG. APPR.		D2750	SHEET 8 OF
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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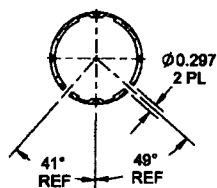
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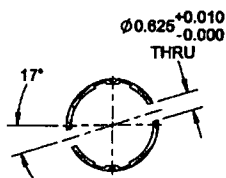
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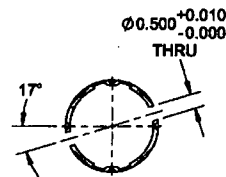
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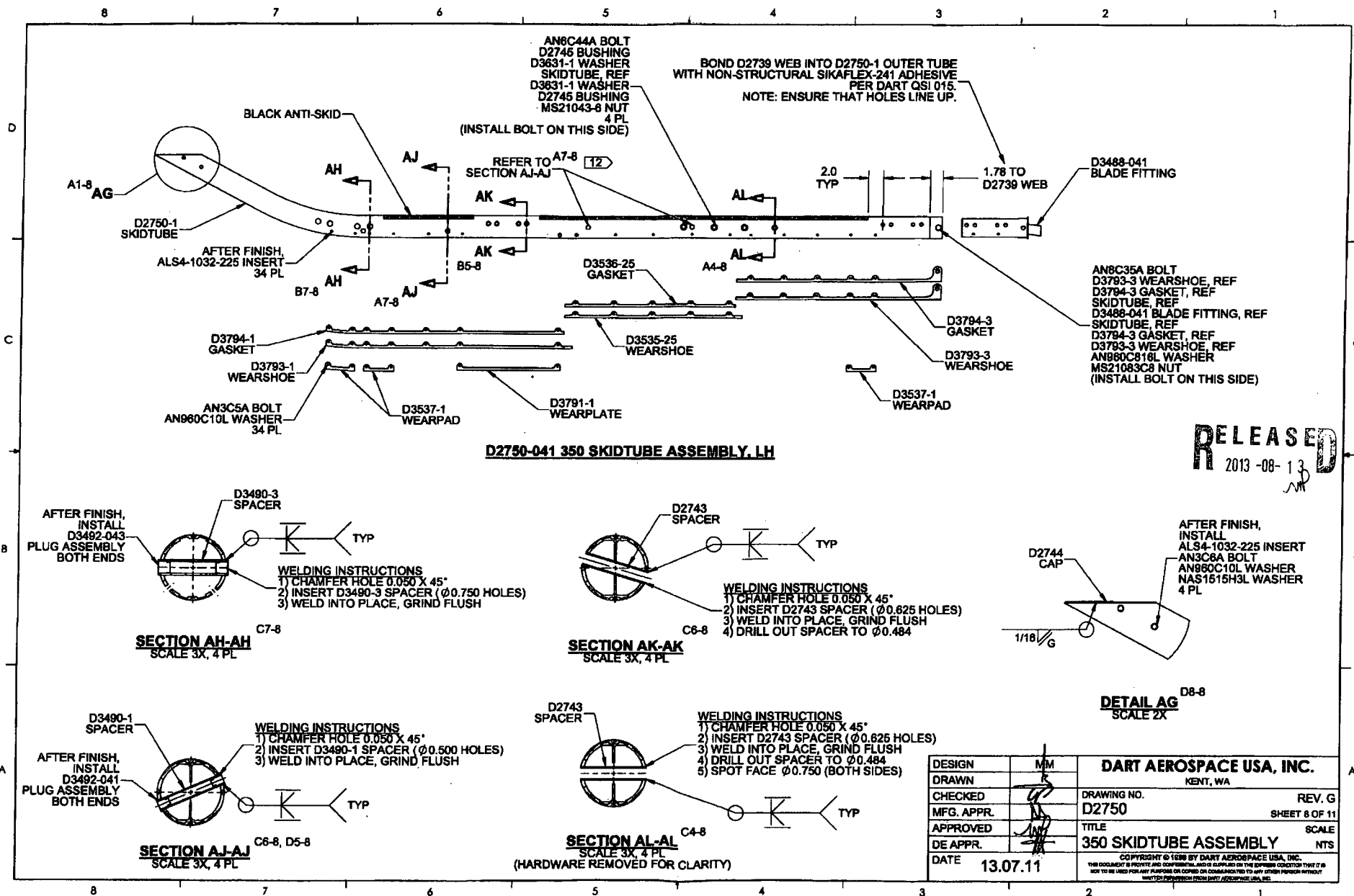
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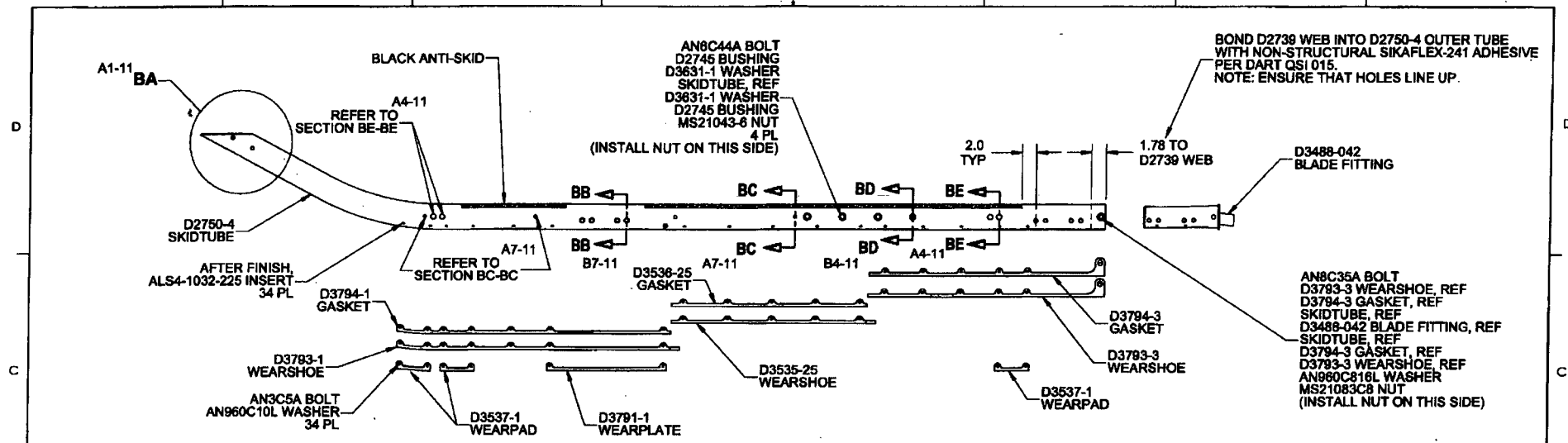
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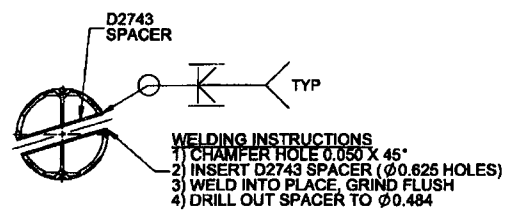
DESIGN	MM	DART AEROSPACE USA, INC.	
DRAWN		KENT, WA	
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MFG. APPR.		D2750	SHEET 7 OF 11
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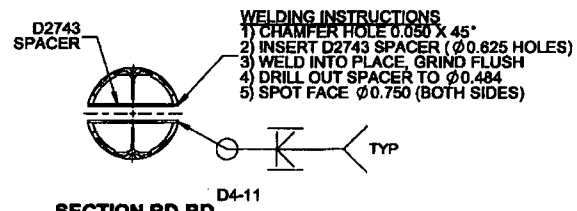
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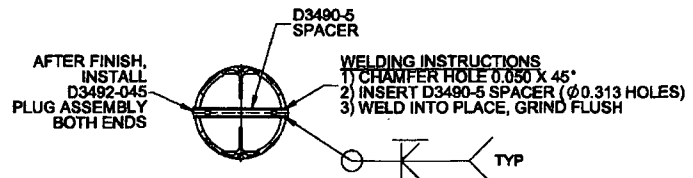
D2750-044 350 SKIDTUBE ASSEMBLY, RH



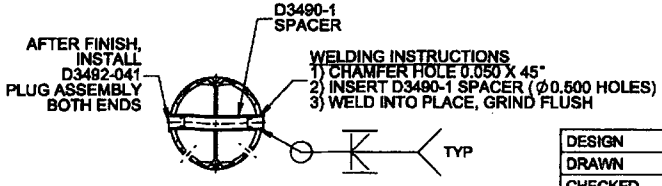
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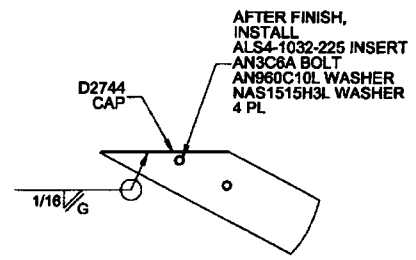
SECTION BD-BD
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION BC-BC
SCALE 3X, 4 PL



SECTION BE-BE
SCALE 3X, 4 PL



DETAIL BA
SCALE 2X

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